(10 D)

Dart Aerospace Ltd.

Date: Thursday, 2/23/2006 10:23:19 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE, INBOARD, LS, 206
Job Number	: 25916		
Estimate Number	: 10820		
P.O. Number	: N/A	**Part Number**	: D26661
This Issue	: 2/23/2006 **S.O. No.** : N/A	**Drawing Number**	: D2666 REV. B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: B
Previous Run	: 24849	**Material**	: N/A
Written By	: See Comment Below	**Due Date**	: 3/22/2006 **Qty:** 12 **Um:** Each
Checked & Approved By	: KH 06.02.23		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock:
Cut Size 2.0 x 6.25 X 6.0
Grain Along Long 6.0 Length
Batch No: B25342

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number.
1-Inspect part number and batch number are programmed correctly.
2-Fixturing W/O No. N/A
3-Fixturing Inspection last completed on 06.06.28 by SA
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr
JL 06/06/30 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet
Ep 06/07/24 x12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE
JL 06/06/30 (12)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 26/07/28

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE, INBOARD, LS, 206

Job Number: 25916 **Part Number:** D26661

Job Number:

Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		06/07/24 12
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		SAD 06/07/25 (12)
7.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		SC 06/07/26 (12) DL
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
	Comment: INSPECT POWDER COAT		AL 06/07/27 (12)
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST471		AL 06/07/27 (12)
10.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL Inspection Level 21		(12) D 06/07/28
Job Completion			KJ 06.07.28

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25916
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.125	.122	.122		
B	0.100	0.140		.128	.125	.123	.124		
C	0.100	0.140		.122	.123	.123	.123		
D	0.210	0.230		.224	.215	.216	.216		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.248	1.250		
G	5.990	6.010		5.997	5.996	5.998	5.997		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.678	1.679		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.236	0.236	0.236		
N	0.100	0.140		.120	.112	.114	.115		
O	0.540	0.560		.549	.549	.548	.548		
P	0.490	0.510		.500	.500	.500	.501		
Q	3.609	3.619		3.612	3.613	3.613	3.613		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.259	.253	.253	.253		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.135	1.130	1.137	1.138		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J-L / ES
Date:	06/06/24 / 06/07/24

Audited by	
Date:	06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	25916
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.123	.124	.124		
B	0.100	0.140		.123	.124	.124	.123		
C	0.100	0.140		.124	.121	.125	.125		
D	0.210	0.230		.218	.216	.219	.219		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	5.990	6.010		5.997	5.997	5.997	5.996		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.678	1.679		
J	2.495	2.505		2.499	2.500	2.499	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.236	0.236	0.236		
N	0.100	0.140		.115	.115	.114	.115		
O	0.540	0.560		.550	.549	.550	.550		
P	0.490	0.510		.500	.500	.501	.500		
Q	3.609	3.619		3.614	3.613	3.613	3.613		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.254	.255	.256	.254		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.134	1.131	1.135	1.135		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL / ER
Date:	06/06/29 / 06/07/24

Audited by	TM
Date:	06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	25916
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.122	.122	.125		
B	0.100	0.140		.123	.122	.123	.125		
C	0.100	0.140		.125	.123	.125	.125		
D	0.210	0.230		.217	.216	.219	.220		
E	1.245	1.255		1.250	1.250	1.249	1.251		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.998	5.998	5.997	.5998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.499	2.498	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.237	0.237	0.238	0.237		
N	0.100	0.140		.117	.119	.118	.120		
O	0.540	0.560		.550	.550	.549	.549		
P	0.490	0.510		.500	.499	.500	.501		
Q	3.609	3.619		3.614	3.613	3.613	3.613		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.252	.252	.253	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.135	1.136	1.137	1.137		
W	1.565	1.585	DT8695 A/B	/	/	/	/		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L / EG
Date:	06/06/30 / 06/07/24

Audited by	ml
Date:	06/07/24

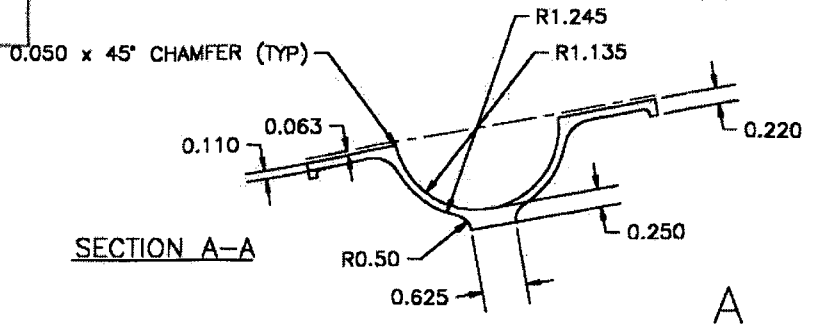
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
	KE	FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2666 — REV. B — SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD INSIDE HIGH — SCALE 2:5

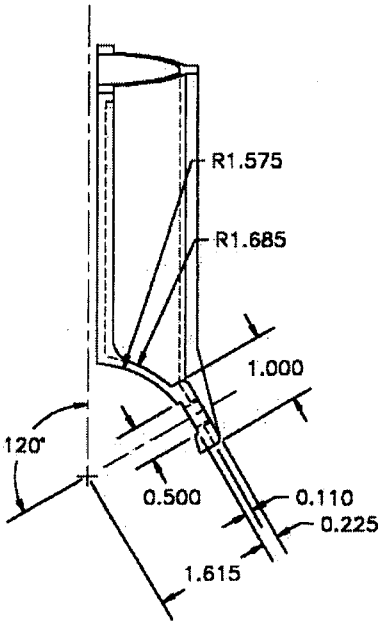
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED

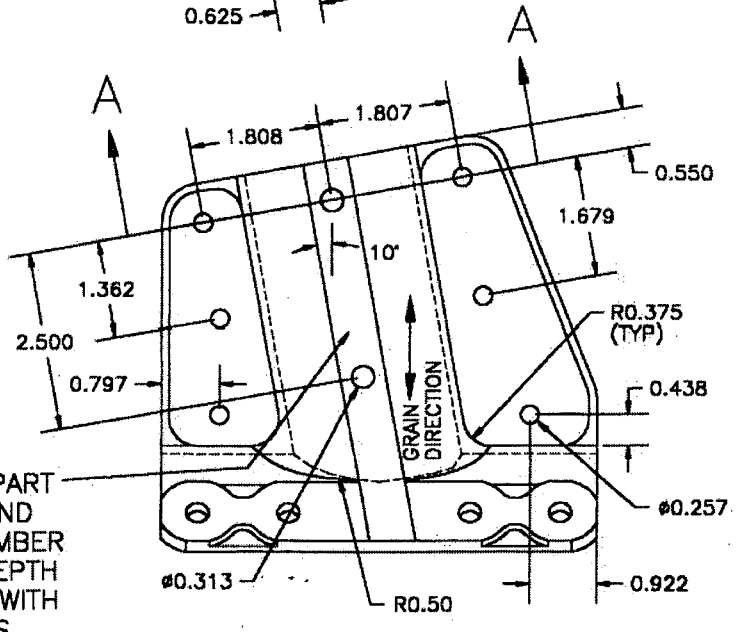
EFFECTIVE	DEOs
9095 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	

DA COPY ISSUED

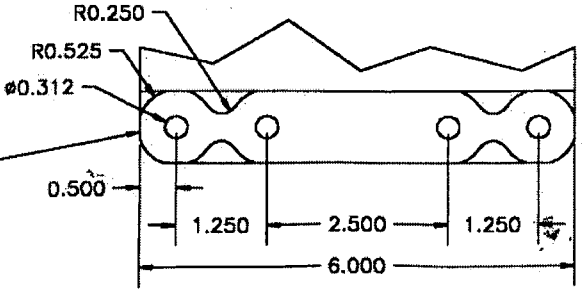


SECTION A–A





ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



RELEASED
97/07/16 DS
ECN 008

MATERIAL: ~~7075 T651 OR~~ 7075–T7351 (QQ–A–250/12)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2
NOTE: D2666–1 SHOWN (D2666–2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO ENGINEERING

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SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 25916